

Thursday, 1/17/2008 3:31:15 PM
Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT TUBE ASSEMBLY
Job Number	: 36842		
Estimate Number	: 10699		
P.O. Number	:	Part Number	: D3391025
This Issue	: 1/17/2008 S.O. No. :	Drawing Number	: D3391 REV G
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LANDING GEAR	Drawing Revision	: G
Previous Run	: 36841	Material	:
Written By	: <u>HA 08 01 18</u>	Due Date	: 2/15/2008 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev B 06-02-07 ECN773 dwg rev. D EC		
	: Est Rev:C 06-03-28 Update Manuf. Instructions JLM		
	: est rev D 07.03.20 revF dwg EC		
	: est rev E 07.11.07 rev G dwg ecn 1053p EC verified		
	: by: DD		
	: Est Rev:F 07-11-13 ECN 1056 DD verified by: EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6014090	ALUMINUM EXTRUSION
-----	----------	--------------------



Comment: Qty.: 1.0000 f(s)/Unit Total : 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty Part Number Description Batch

1 D6014-090 Extrusion 26546

Identify as D3391-3

20 08/01/26

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599 Rev: G & Dwg D3391 Rev: G

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 08/01/26 ①

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS

1-Machine as per Folio FA 599 Rev: G & Dwg D3391 Rev: G

2-Deburr

SA 08/02/20 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:31:15 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 36842

Part Number: D3391025

Job Number:



Seq. #

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 08/02/20

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

6/08.02.21

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

EL 8-2-26

8.0

BENDING

BENDING MACHINE



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

EL 8-2-26

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 8-2-26

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'sink as per dwg D3391.

6-Open up all wearshoe, wearplate and float bag holes as per Dwg D3391.

7-Deburr

Tools: rill

DP 8-2-26
8-2-27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

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Drawing Name: AFT TUBE ASSEMBLY

Job Number: 36842

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

QC5

INSPECT WORK TO CURRENT STEP



08-02-27



Comment: INSPECT WORK TO CURRENT STEP

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(IX)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-2/HR 08/02/27

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/03/08

14.0

D36704200

SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

SPACER

batch: *35938*

DP 8-3-4

15.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Instal spacers as per dwg D3391

A/R Magnabond 6398 Batch: *1105379*

exp. date: *8-5-30*

cure time 12hrs as per QSI0015

DP 8-3-4

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/05

17.0

POWDER COATING

POWDER COATING



M107005



(IX)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-1 08/03/06

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 08-03-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:31:16 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 36842

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

Qty Part Number Description Batch
1 D2646 Aft Cap

B 36184

BR

20.0

D35371

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

B 36714

BR

21.0

D35377

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearpad

B 33869

BR

22.0

D35531

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

B 33868

BR

23.0

D35533

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

B 33870

BR

24.0

D36721

PHENOLIC WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PHENOLIC WASHER

B 34470

BR

25.0

ALS41032130

Insert



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

INSERT

batch

or equivalent per

QSI 017

M 105730

BR

BR 08-08-07

①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:31:16 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 36842

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

ALS41032225

Insert



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

INSERT

or equivalent

Per QSI 017

m 100489

BL

27.0

AN3C4A

BOLT:



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

2 AN3C4A Bolt

m 107008

BL

28.0

AN3C5A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

m 106780

BL

29.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Inventory

Pick:

Qty Part Number Description Batch

2 AN960C10L Washer

m 107008

BL

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts as per Dwg D3391

> BL

08-03-06

①.

2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-241/-291

105585

Sikaflex expiry date:

08-07

> BL

08-03-06

①

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/03/07 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/03/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 36842

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

fl

08-03-06

①

33.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D0810310

②

Job Completion



m 2008/3/12

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 36842
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: G	Page 1 of 1

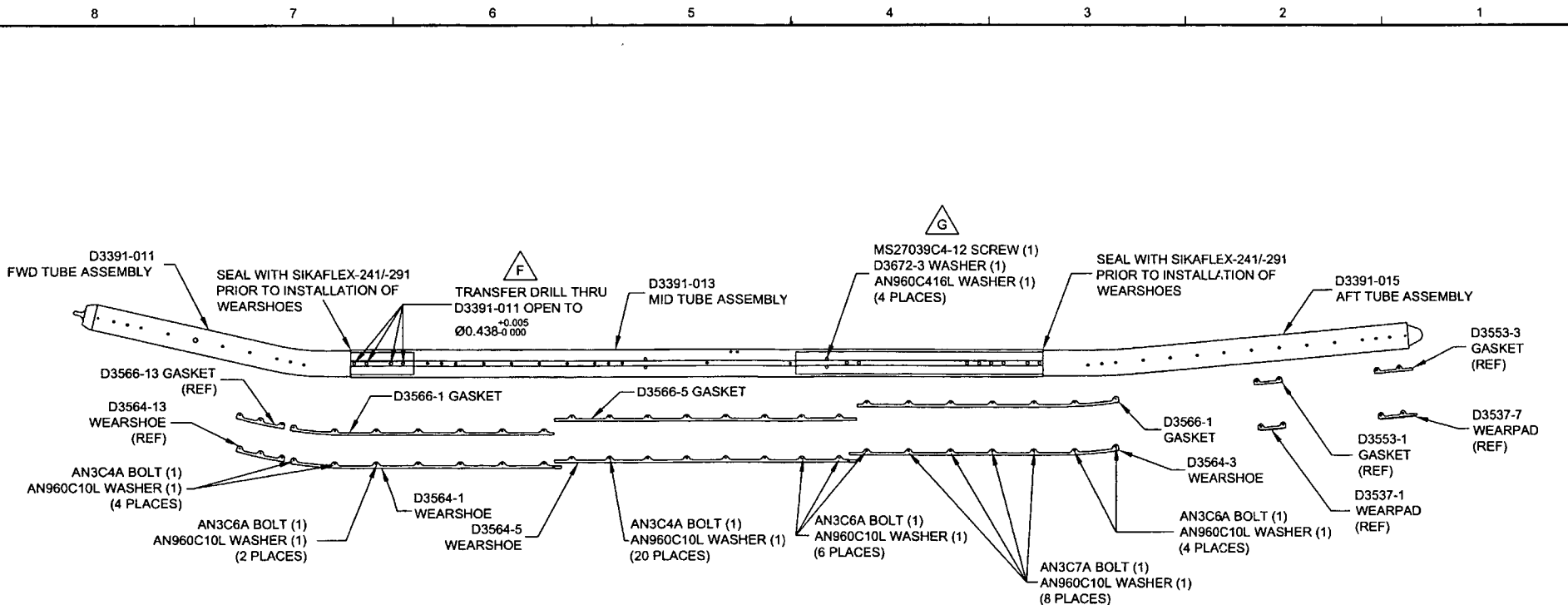
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.000	/			
3.500	+/-0.010	3.495	/			
88.93	+/-0.030	88.937	/			
44.995	+/-0.030	44.998	/			
3.200	+/-0.010	3.201	/			
1.526	+0.000/-0.030	1.526	/			
0.200	+/-0.010	.198	/			
7.500	+/-0.010	7.500	/			
27.750	+/-0.010	27.750	/			
31.750	+/-0.010	31.750	/			
35.250	+/-0.010	35.250	/			
3.300	+/-0.010	3.296	/			
0.200	+/-0.010	.199	/			
3.520	+/-0.010	3.513	/			
0.687	+0.010/-0.000	.688	/			
R0.062	+/-0.010	R.062	/			
Ø0.484	+0.005/-0.001	Ø.488	/			

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 08/01/28	Date: 09.02.21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	<i>[Signature]</i>



RELEASED
07-11-07

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS. DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWJ SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.31		

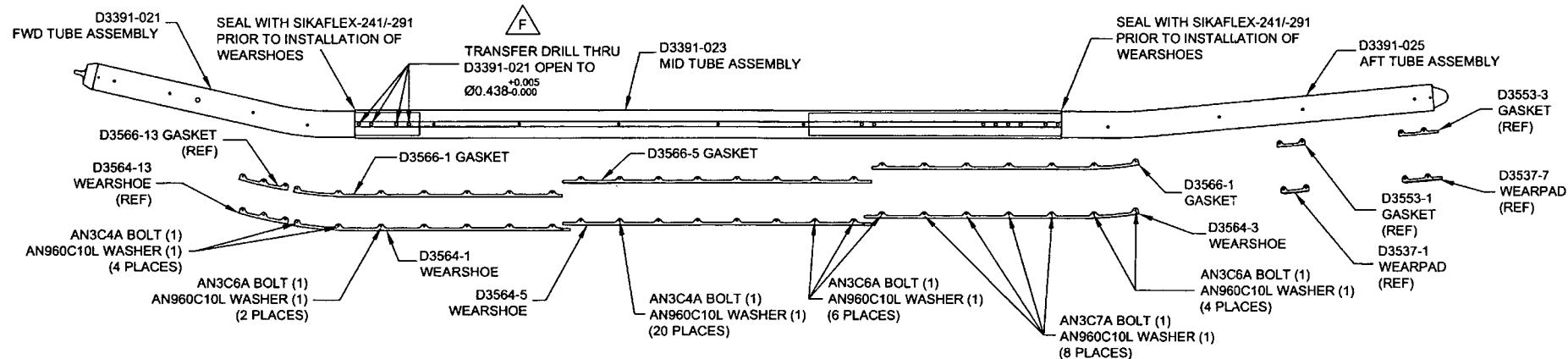
DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3391
REV. G
SHEET 1 OF 8

TITLE 412 FLOAT SKIDTUBE
SCALE NTS

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 NO. 308412
 07-11-07



D3391-043 ASSEMBLY

RELEASED
07.11.21

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

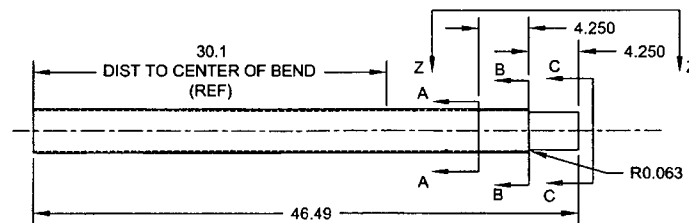
GENERAL NOTES

- 1) FINISH. CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS
OFF POWDER COATING WITH MEK DEGREASER.
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT
WHERE INDICATED.

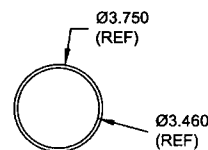
DESIGN	PH	DART AEROSPACE USA, INC
DRAWN	JLC	PORT HADLOCK, WA
CHECKED	JLC	DRAWING NO. D3391
MFG. APPR.	JLC	REV. G
APPROVED	JLC	SHEET 2 OF 8
DE APPR.	JLC	TITLE 412 FLOAT SKIDTUBE
DATE	07.07.31	SCALE NTS

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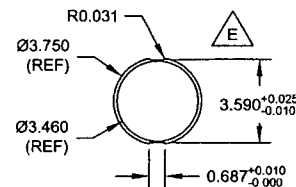
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FOR ORDER
RETURN TO
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WITHOUT NOTICE



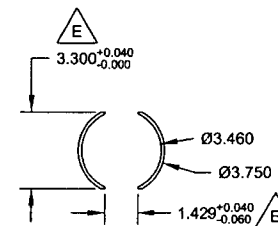
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



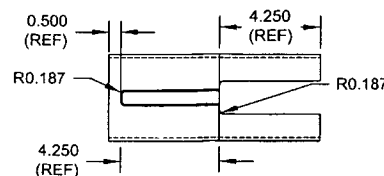
SECTION A-A
(SCALE 1:5)



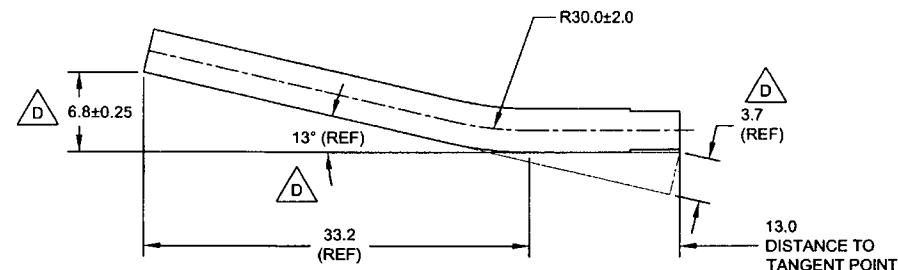
SECTION B-B
(SCALE 1:5)



SECTION C-C
(SCALE 1:5)



VIEW Z-Z
(SCALE 1:5)

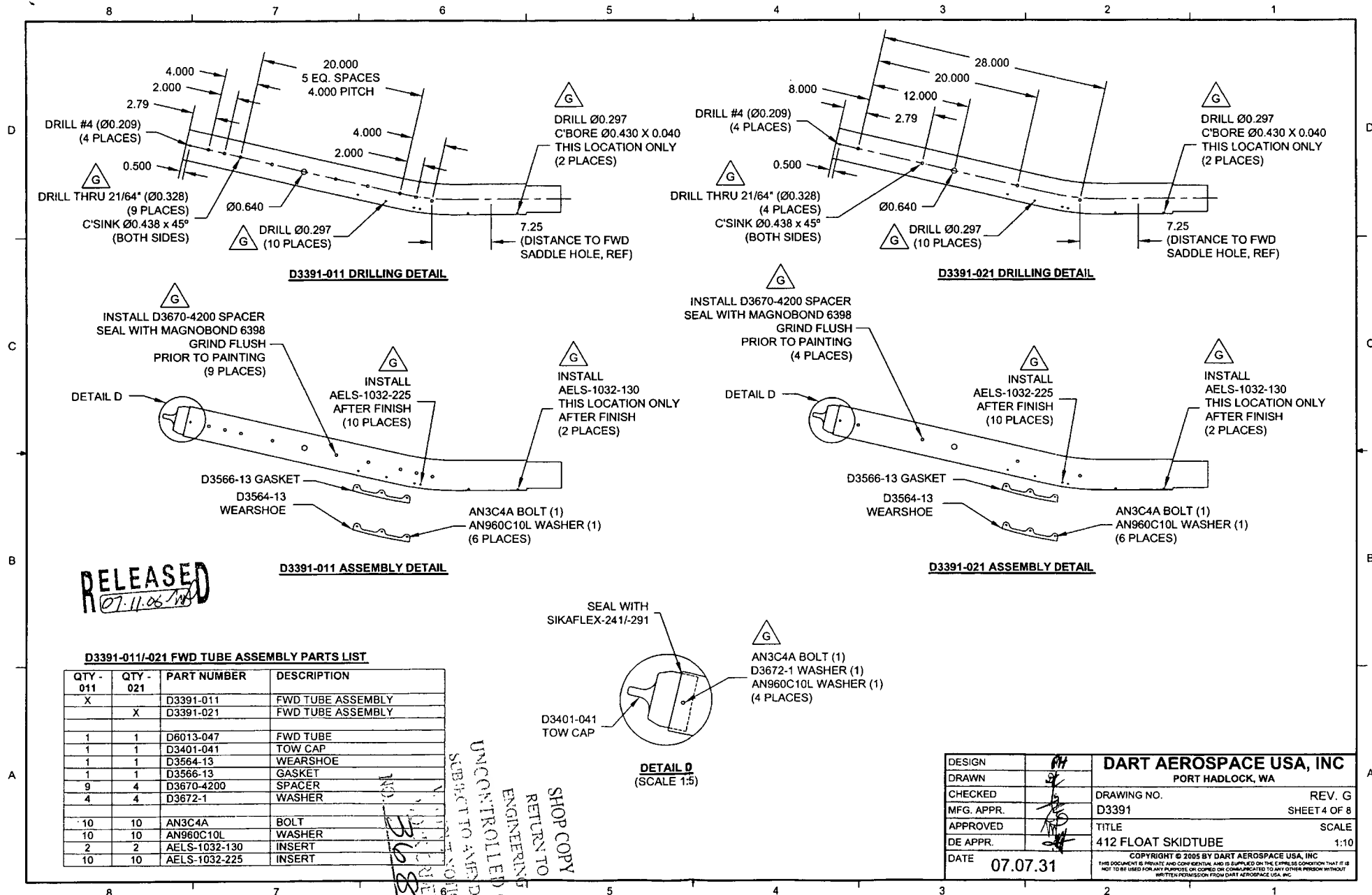


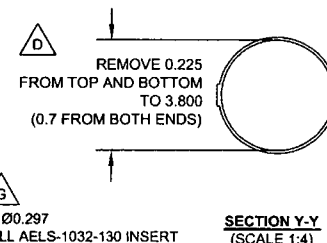
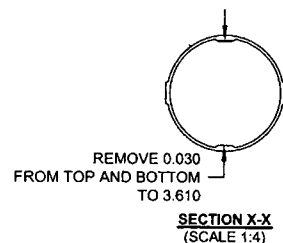
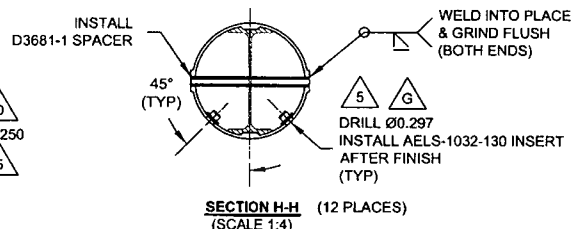
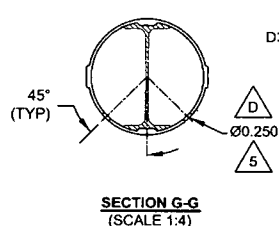
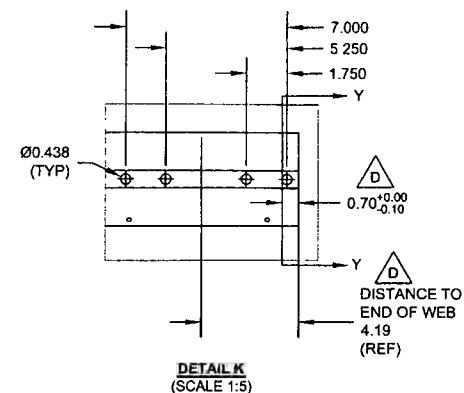
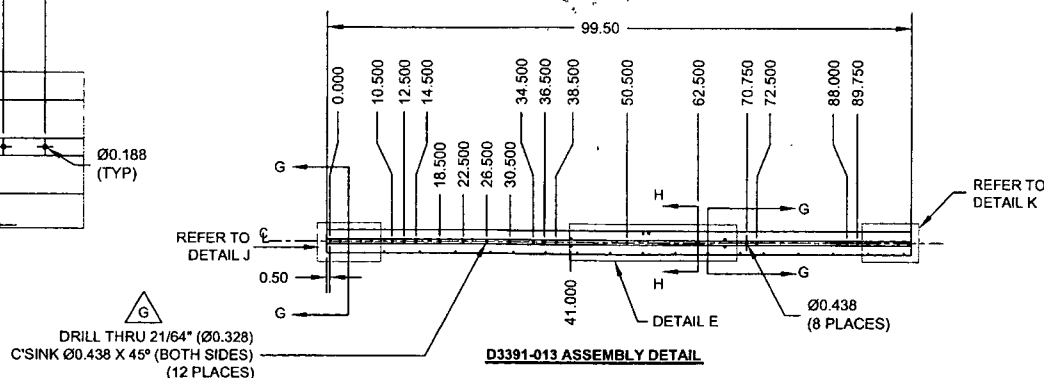
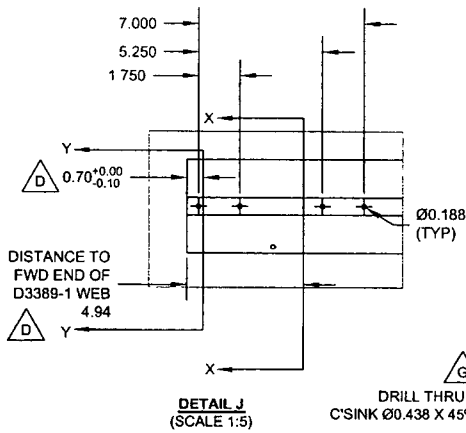
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)

RELEASED
07-11-06 MP

NO. 26842
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

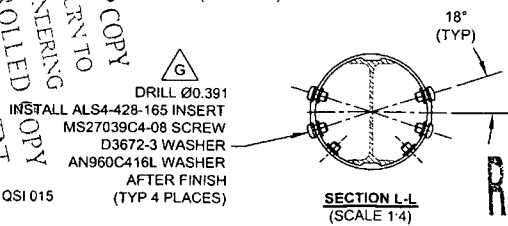
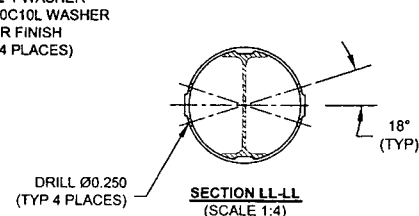
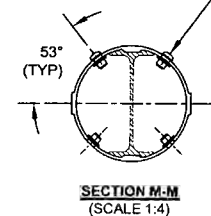
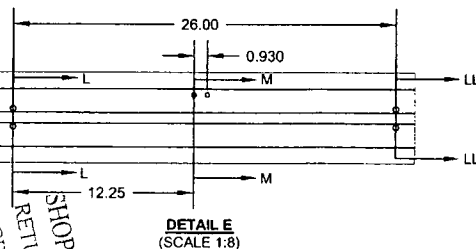
DESIGN		DART AEROSPACE USA, INC	
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MFG. APPR.		D3391	SHEET 3 OF 8
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DE APPR.		412 FLOAT SKIDTUBE	1:10
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D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
12	D3681-1	SPACER
4	D3672-1	WASHER
4	D3672-3	WASHER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW



D3391-013 MID TUBE ASSEMBLY

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- WELDING: PER DART QSI 004

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